



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

139 VALVE

607.3301

Job Sheet 213820

Accounting Job SE CAD 139 Valve



Part No: 607.3301

Job Qty: 1 pcs

Part Name: Valve Pull Force Test Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/20

Job Tracking No:

Due Date: 10/28/20

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: 607.3300 Rev.NC IPP REV:A 20.10.06 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	10/28/20	10/28/20	0.00	1.00	Small Fab - 1		21 19-10-20
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
							Small Fab - Various 1		
							Small Fab - SCH-S		
120	QC 5	1 pcs	10/28/20	10/28/20	0.00	0.00	QC 5 - 10		DAS 82 9-89 OCT 19 2020
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		

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				QC 5 - SCH-B	
130 Packaging 3-1 - Stock - B4B 1 pcs	10/28/20	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	DAI
				Packaging 3 - 12 - B4B	19
				Packaging 3 - 13 - B4B	9-88
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
				Packaging 3 - SCH-B	
140 QC 21 - FG 1 pcs	10/28/20	0.00 0.00		QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 9	OCT 19 2020
				QC 21 - FG - 77	DAS
				QC 21 - FG - 28	70
				QC 21 - FG - SCH-B	9-89

Part Op 110 - ASSEMBLE AS PER DWG

Descriptions: 120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock in the Critical Valve Assembly room

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
645.7110	Lock Nut Swivel	1 pcs (1 ea)	110-Small Fab - 1	306168
645.7810	Cable Rod	1 pcs (1 ea)	110-Small Fab - 1	305809
645.7910	Cable Housing	1 pcs (1 ea)	110-Small Fab - 1	305967
650.7910	Shroud	1 pcs (1 ea)	110-Small Fab - 1	5305840
CBL-1240	Cable	1 ft (1 ea)	110-Small Fab - 1	198626
CBL-460	Loop Sleeve	1 Ea (1 ea)	110-Small Fab - 1	251780
MS24665-103-ZV		2 Ea (2 ea)	110-Small Fab - 1	116355

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	645.7110	1	0	0
	645.7810	1	0	0
	645.7910	1	0	0
	650.7910	1	0	0
	CBL-1240	1	141	0
	CBL-460	1	66	0
	MS24665-103 -2V	2	25	0
Part Specifications				
Specifications could not be found.				

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Released on 8/28/2020

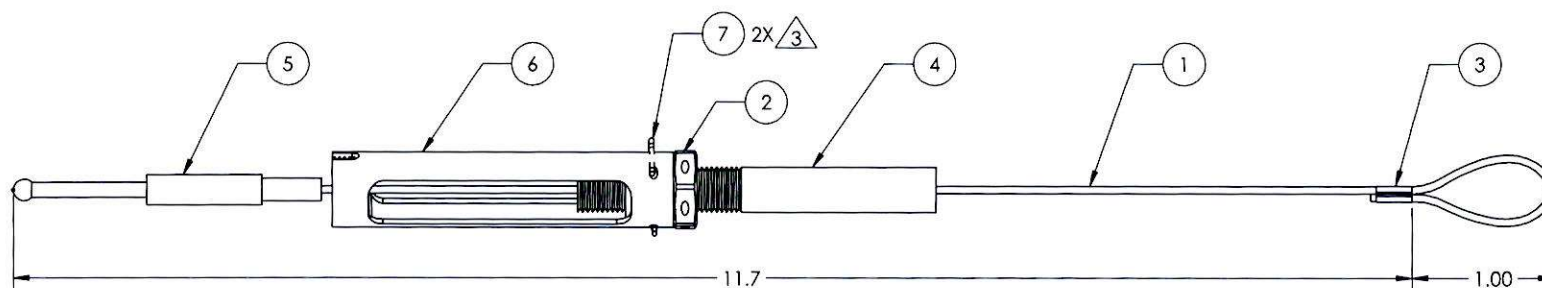
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	08-19-20	A.QUAN

NOTES:

1. IDENTIFY IAW MPP-120
2. SWAGE USING NICOPRESS NO.1-SC HAND SWAGER. SWAGE UNTIL JAWS ARE COMPLETEY CLOSED.
3. LOCK SHROUD F/N 6 IN PLACE WITH SWIVEL LOCK NUT F/N 2 USING COTTER PINS F/N 7, APPROXIMATELY AS SHOWN.



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WITHOUT NOTICE
WORK ORDER
NO. 213820 mls

20-10 07

QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
2	7	601.2330	COTTER PIN		
1	6	650.7910	SHROUD	ALT 645.7710	
1	5	645.7810	CABLE ROD		
1	4	645.7910	CABLE HOUSING		
1	3	601.1054	CRIMP SLEEVE		2
1	2	645.7110	LOCK NUT SWIVEL TYPE		
1FT	1	601.1581	CABLE		
X		607.3301	VALVE PULL FORCE TEST TOOL		

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE (MM-DD-YY) 08-19-20	
		DRAWN BY A. FLORES	
		CHECKED J. BECKER	
		DRAWING APPROVAL A. QUAN 08-19-20	
		CONTRACT NO.	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 ANGLES ±.5°	
SHEET B	CAGE CODE 07M26	DWG. NO. 607.3300	REV. N/C
SCALE NONE		SHEET 1 OF 1	

DART 3030 ENTERPRISE CT., SUITE A
VISTA, CA 92081
(760)-724-5300
APICAL INDUSTRIES, INC.
DBA DART AEROSPACE

VALVE PULL FORCE
TEST TOOL

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>213820</u> Part No. <u>607.3301</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : <u>20.10.07</u>	Sequence #: <u>110</u>	QTY Affected : <u>1</u>		DAS MRB (QSI042) <u>51</u> <u>SN</u> <u>9-89</u> <u>20/10/07</u>	
Description Work Order Deviation replace the P/Ns listed on the drawing with the following P/Ns 601.1581 → CBL-1240 (Cable) 601.1054 → CBL-460 (Crimp Sleeve) 601.2330 → MS24665-103 (Cotter Pin)			Disposition these changes were made to reduce lead time		
			Completed By <u>AS</u> <u>20-10-19</u>		
			Lead hand / Supervisor DAS <u>58</u> <u>9-89</u> <u>OCT 19 2020</u>		
			QC / QA Coordinator DAS <u>55</u> <u>9-89</u> <u>19 OCT 2020</u>		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☒ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			

Ketan Tailor

From: Jacob Becker
Sent: October-07-20 4:57 PM
To: Ketan Tailor
Cc: Steven Drouin
Subject: RE: Deviations for Valve Pull Force Test Tool

Understood.

Per our conversation these deviations are acceptable.

Regards,

JACOB BECKER
Lead Sustaining Engineer

DART AEROSPACE
T 1 760 509-1639
M 1 760 691-9108

From: Ketan Tailor <ktailor@dartaero.com>
Sent: Wednesday, October 07, 2020 1:48 PM
To: Jacob Becker <jbecker@dartaero.com>
Cc: Steven Drouin <sdrouin@dartaero.com>
Subject: RE: Deviations for Valve Pull Force Test Tool

Hey Jacob,

We measure the CBL-1240 Cable we have in stock and we will not deviate the 645.7810 Cable Rod.

The diameter of the uncoated Cable was 0.063".

Thanks,
Ketan

From: Ketan Tailor
Sent: October-07-20 4:35 PM
To: Jacob Becker <jbecker@dartaero.com>
Subject: Deviations for Valve Pull Force Test Tool

Hey Jacob,

We would like to make changes to the following P/Ns in order to decrease the lead time for the 607.3301 Valve Pull Force Test Tool

607.3301 Valve Pull Force Test Tool

- Replace 601.1581 Cable with CBL-1240
- Replace 601.1054 Crimp Sleeve with CBL-460
- Replace 601.2330 Cotter Pin with MS24665-103

650.7910 Shroud

- Omit outsourcing for Passivation

645.7910 Cable Housing

- Omit outsourcing for Passivation

~~645.7810 Cable Rod~~

- ~~Dimension was 0.072 +/- 0.005 is 0.063 +0.004/-0.001~~

645.7110 Lock Nut Swivel Type

- Omit outsourcing for Electropolish and Passivation.

Please confirm if these changes are acceptable.

Thanks,
Ketan